



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEL135M-2905-101-13
Job Sheet 187594



Part No: RBEL135M-2905-101-13

Job Qty: 4 ea

Part Name: Motor Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/10/18

Job Tracking No:

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEL135M-2905-101 REV 9 IPP REV A 18.05.24 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
Hrs	Hrs								
90	Start up Operation	4 Ea	12/21/18	12/21/18	0.00	0.00	Start Up Machining-2		DAS 56 9-89
94	CNC Lathe	4 pcs	12/21/18	12/21/18	0.00	1.33	SL2500Y		
100	QC	4 pcs	12/21/18	12/21/18	0.00	0.00	QC2 Machining-4		
102	CNC Vertical Machining	4 pcs	12/21/18	12/21/18	0.00	1.33	HAAS1-1		
104	QC	4 pcs	12/21/18	12/21/18	0.00	0.00	QC2 Machining-4		
105	CNC Vertical Machining	4 pcs	12/21/18	12/21/18	0.00	1.00	NV5000-1		
120	QC	4 pcs	12/21/18	12/21/18	0.00	0.00	QC2 Machining-4		
140	QC	4 pcs	12/21/18	12/21/18	0.00	0.00	QC8 Machining-4		
150	Outsource	4 pcs	12/21/18	12/21/18	0.00	0.00	Outsource4		
160	Packaging	4 pcs	12/21/18	12/21/18	0.00	0.00	Packaging2		
170	QC	4 pcs	12/21/18	12/21/18	0.00	0.00	QC6		
180	Packaging	4 pcs	12/21/18	12/21/18	0.00	0.00	Packaging3-1		
190	QC21-SA	4 Ea	12/21/18	12/21/18	0.00	0.00	QC21		

Part Op 94 - 1-Machine as per DWG. FC 563 FOLIO REV: AA DWG REV: 9-21 2-Debur
Descriptions: 102 - 1-Machine as per folio FC 563 FOLIO REV: AA DWG REV: 9-89 2-Debur
105 - 1-Machine as per folio FC 563 FOLIO REV: AA DWG REV: 9-89 2-Debur
150 - Issue P/O to GROUPE ALTECH; PO 042251 - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2
CLASS 1, Water sealant -Certificate of Conformity is required

- COUNTERBORE Ø0.331" HOLE TO Ø0.655 SLUSH TO SURFACE

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.750	6061-T6 Round Bar 3.750"	.4600 ft (.115 ea)	90-Start up Operation	

Job Allocations

Required	Inventory	Allocated
0	14	0

ations

not be found.

Plex 12/10/18 10:22 AM Dart.lajeunesse.marie



Container No: S142123



Part: RBEL135M-2905-101-13

Job No: 187594

Serial No/Batch: S142123

Revision: 9

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/06/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

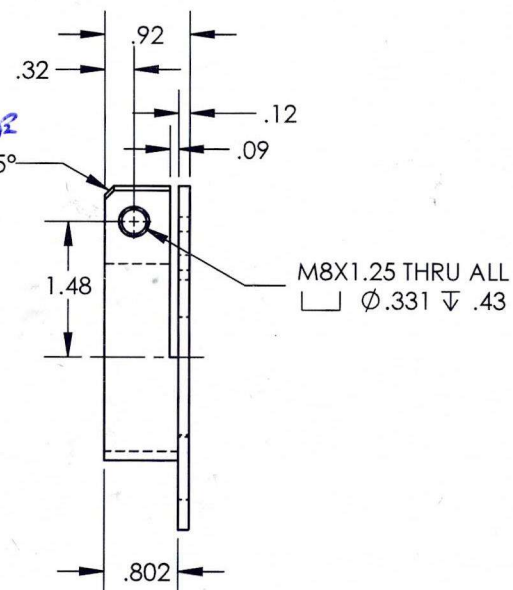
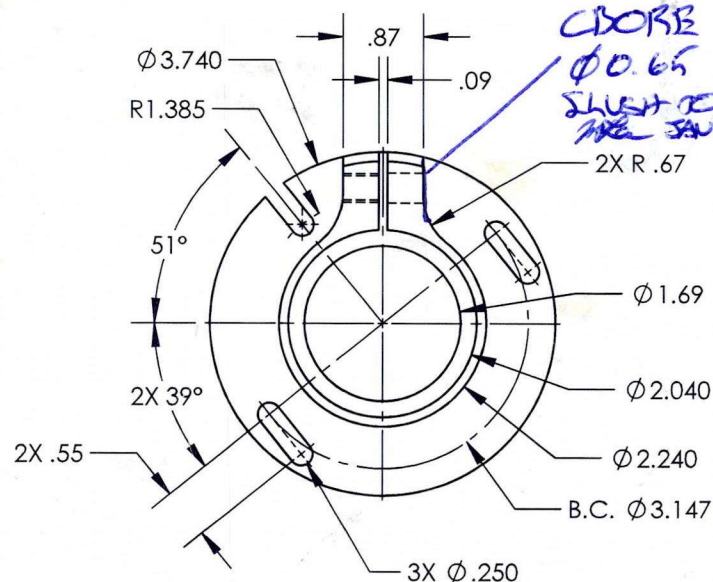
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :		Sequence #:		QTY Affected :	MRB (QSI042)
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
2		CHANGED -13 MOTOR CLAMP TO FIT NEW MOTOR.	9/14/2010
9	16-0222	-13 CH'D DIM WAS .09 CUT RELIEF IS .09 TWO INSTANCES.	11/23/2016



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 187594 MW

187D-10

(-13)

MOTOR CLAMP

DART AEROSPACE	
TITLE HYDRAULIC PUMP DRIVE TOOL	
DWG NO. RBEL135M-2905-101-13	REV 9
MAT'L 6061 TREAT FINISH CLEAR ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS I	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm .005$ FRACTIONS $\pm 1/8$.XX $\pm .01$ ANGLES $\pm .5^\circ$.X $\pm .1$ SURFACES $\pm .125$
DRAWN BY: PERRITT CHECKED: DUERFELDT OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 $\times 45^\circ$ OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EUROCOPTER EC135
SCALE 1:2	DATE 4/23/2010
SHEET 9 OF 18	

DART AEROSPACE LTD	Work Order:	
Description: HYDROLIC PUMP DRIVE TOOL MOTOR CLAMP	Part Number:	RBEL135M-2905-101-13
Inspection Dwg: RBEL135M-2905-101-13 Rev: 9		Page 1 of 1

[illegible]

Engineering Approval: (If necessary)	Date:
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042251



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042251
PO Date: 1/14/19
Due Date: 1/22/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187594	RBEL135M-2905-101-13	Motor Clamp -Issue P/O to GROUPE ALTECH; PO _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	1/22/19	6 pcs	0 pcs	6 pcs	\$6.00/pcs	\$36.00
2	188491	RBEL135M-2901-101-09	Drive Pulley (Outsource process- Anodize per QSI017 4.1.10.1), -Issue P/O; PO _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	1/22/19	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00
3	187709	RBE703A94-1130-01-25	Tab Adjuster Handle -Issue P/O to ATG: PO _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water Seal - Certificate of Conformity is required	Firmed	-	1/22/19	10 pcs	0 pcs	10 pcs	\$6.00/pcs	\$60.00

Grand Total: \$120.00



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Canada

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PURCHASE ORDER PO042251



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/14/19 10:11 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(015956-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015956 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
17-Jan-2019		Aman		042251					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBEL135M-2905-101-13 ✓ Rev.	RBEL135M-2905-101-13 ANODIZE COLOR CLEAR PER IAW MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	6	6 ✓	0	0	0	
2	RBEL135M-2901-101-09 ✓ Rev.	RBEL135M-2901-101-09 ANODIZE CLEAR PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT	ANODIZE CH	4	4 ✓	0	0	0	
3	RBE703A94-1130-1-25 ✓ Rev.	RBE703A94-1130-1-25 ANODIZE COLOR CLEAR PER IAW MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	10	10 ✓	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.